

Work Order ID 161539

Wednesday, May 17, 2017 12:38:31 PM

161539

Page 1

Item ID: 646.3814

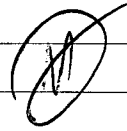
Revision ID:

Item Name: Wiper Bracket

Start Date: 5/23/2017 Start Qty: 10.00

Required Date: 6/2/2017 Req'd Qty: 10.00

Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAY 17 2017 Tooling:

QC: _____ Date: _____ SPC (Y/N): _____

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.4000									

110	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 33 9-89 17/05/27
-----	--------------------------------	------	--	--	--	--	--	--	-------------------------------

110

Mill Conv

Conventional Milling Machine

Haas #1

17/05/24

Memo

1-Machine per DWG and Folio FB539

DWG REV: N/C

2- deburr and break all sharp edges

120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 33 9-89 17/05/27
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120

QC

Quality Control

Memo

105

Bandsaw

Cut blank at 2.200"

									DAS 33 9-89 17/05/27
--	--	--	--	--	--	--	--	--	-------------------------------

17/05/24

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Item ID: 646.3814 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wiper Bracket
Start Date: 5/23/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/2/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				10	0		DAS 14 9-89
130	Memo	0.00							17/05/29
QC									
Quality Control									

131		0.00							
131	Memo	0.00							
Small Fab									
Small Fab	ROLL AS PER DWG								

132	QC5- Inspect part completeness to step on W/O	0.00							
132	Memo	0.00							
QC									
Quality Control									

QFS
17/05/24

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 Required Date: 6/2/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							DAS 13 9-89

140

Outsource4

Outsource process - Anodize

Memo

Issue P/O: 36583

1- Black Anodize as per Dwg 646.3800

2- Prime as per Dwg. (see note #2)

Certification of Conformity is required.

Receive & Inspect for Damage & Mat'l Certs

150

150

Packaging

Packaging

Memo

155

155

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

10 JUN 06 2017

10X SP17-6-16

10 JUN 16 2017

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Item ID: 646.3814

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wiper Bracket

Start Date: 5/23/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 10.00

10

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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~~160~~~~Spray Painting per QSI005 4.2~~~~0.00~~~~***160***~~~~SprayPaint~~~~Memo~~~~0.00~~~~Spray Painting~~~~PRIME AS PER DWG, SEE NOTE #2~~~~CARDINAL 4860-50 PRIMER BATCH: _____~~~~170~~~~QC14- Inspect Spray Paint~~~~0.00~~~~***170***~~~~QC~~~~Memo~~~~0.00~~~~Quality Control~~

180

Identify as per dwg & Stock Location: CCK100

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DAS

6

9-89

JUN 16 2017

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Item ID: 646.3814 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wiper Bracket
Start Date: 5/23/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/2/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

JUN 16 2017

Picklist Print

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Work Order ID: 161539

161539

Parent Item: 646.3814

646.3814

Parent Item Name: Wiper Bracket

Start Date: 5/23/2017

Required Date: 6/2/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B0.750X1.250		Purchased		No			f	0.0000		1.747368			

~~*M7075T6B0.750X1.250*~~

**

M7075T6B0.750X1.250

M7075T6 B 1.250 X 1.000 (this batch only)

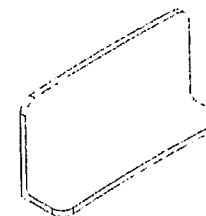
m132142

1.85

Kt 17-05-20

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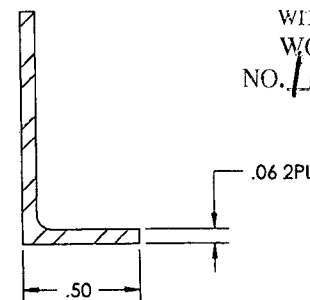
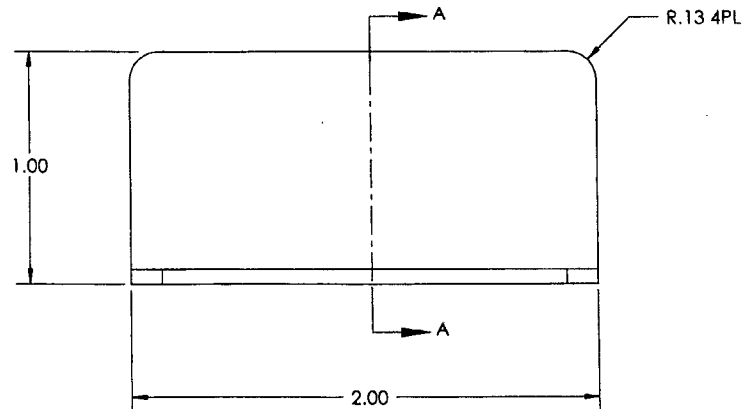
REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3814

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 161539

MAY 17 2017



SECTION A-A

NEXT ASSY (S)		OVERALL DATE (MM-DD-YY)	05-19-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 BRACKETS		
		DRAWN BY	CHICKER			
		DESIGNED BY				
		DRAWING APPROVAL				
		CONTRACT NO.		SHEET (CAGE CODE) DWG NO. 646.3800 B 07MZ6 N/C SCALE NONE SHEET 5 OF 5		
		UNLESS OTHERWISE SPECIFIED (DIMENSIONS ARE IN INCHES)				
		TOLERANCES ARE:				
		2 PLACE DECIMALS ±.010				
		3 PLACE DECIMALS ±.005				
		ANGLES ±.5°				

David Duval

From: Chantal Lavoie
Sent: May-05-17 1:53 PM
To: David Duval
Subject: FW: 17814
Attachments: M7075T6B-RevB.pdf; 646.3000 NC1 Lower Cutter Assy [ECN 02195].pdf; D4842-RevB.pdf

Follow Up Flag: Follow up
Flag Status: Flagged

From: Chantal Lavoie
Sent: Tuesday, May 02, 2017 11:57 AM
To: 'Eric Downing' <edowning@dartaero.com>
Subject: FW: 17814

Hi Eric,
Check this e-mail, for 7075-t6 bar or cut from plate.
Thanks
Chantal

From: Chantal Lavoie
Sent: Tuesday, May 10, 2016 1:20 PM
To: Chris Provencal <cprovencal@dartaero.com>
Cc: 'Eric Downing' <edowning@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: FW: 17814

Hi Chris,
I found another problem when ordering material, see attached for mill spec's 7075-T6.
Material spec's call out 7075-T6/T651 etc..... But with no indication of AMS or QQ-A accepting T651.
Please advise if you can sign deviation would need to order some material.

Note: this material is used for cable cutter part if you look at dwg from Apical (646.3000) they call out 7075-T651 under AMS-QQ-A-250/12, see attached for dwg files.

Dart dwg (D4842) only call out 7075-t6 see attached for dwg files. 95% of 7075-T6 material will be under 7075-T651/AMS-QQ-A-250/12.

Thanks
Chantal

From: Linda Lacelle
Sent: Tuesday, May 10, 2016 1:02 PM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: FW: 17814

From: Pablo Bravo [<mailto:pbravo@apicalindustries.com>]

Sent: Friday, September 21, 2012 11:08 AM

To: 'Jean-Luc Menard' <jmenard@dartaero.com>; 'Linda Lacelle' <llacelle@dartaero.com>; 'David Shepherd' <dshepherd@dartaero.com>; 'Mike Petsche' <mpetsche@dartaero.com>

Cc: 'Isam El-Kassis' <ielkassis@dartaero.com>; 'Chantal' <clavoie@dartaero.com>; 'Bill Beckett' <bbeckett@dartaero.com>; 'Steve Joseph' <sjoseph@apicalindustries.com>

Subject: RE: 17814

After looking at this more closely, we should be able to use the AMS-QQ-A-250/12 that was originally quoted. No objection on this side to the material change. Let me know what documentation you need to make this happen.

Thanks,

Pablo

From: Jean-Luc Menard [<mailto:jmenard@dartaero.com>]

Sent: Friday, September 14, 2012 5:30 AM

To: 'Linda Lacelle'; 'David Shepherd'; 'Mike Petsche'

Cc: 'Isam El-Kassis'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'

Subject: RE: 17814

THE 1.250" x 2.00 " would be used on the rail 647.0200.

JL

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]

Sent: Friday, September 14, 2012 7:59 AM

To: 'David Shepherd'; 'Mike Petsche'

Cc: 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'

Subject: RE: 17814

JL will get the info on what part it is used in, as the boms are not made yet.

LL

From: David Shepherd [<mailto:dshepherd@dartaero.com>]

Sent: September-14-12 8:12 AM

To: 'Linda Lacelle'; 'Mike Petsche'

Cc: 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'

Subject: RE: 17814

Linda,

My understanding is that Pablo Bravo will have to make ALL MRB decisions on the cable cutters since Apical owns the STC.

Therefore, you will need to send an email to Pablo to get a disposition on these types of issues.

What Apical p/n is this for?

PB,

Is the material substitution requested below acceptable?

If not, can you provide guidance on where you were purchasing this material so that Dart purchasing can track it down.

David

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: September-13-12 10:23 AM
To: 'Mike Petsche'
Cc: dshepherd@dartaero.com; 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'
Subject: RE: 17814

Ok,so where do we go from here?

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: September-13-12 11:51 AM
To: Linda Lacelle
Cc: <dshepherd@dartaero.com>; Isam El-Kassis; JEANLUC MENARD; Chantal
Subject: Re: 17814

Cable cutters are largely outside of engineering. We are only manufacturing for apical. Using all apical data.

Sent from my iPhone

On 2012-09-13, at 11:40 AM, "Linda Lacelle" <llacelle@dartaero.com> wrote:

Any news on this pls?

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: September-11-12 12:57 PM
To: dshepherd@dartaero.com; 'Mike Petsche' (mpetsche@dartaero.com)
Cc: Isam El-Kassis (ielkassis@dartaero.com); JEANLUC MENARD (jmenard@dartaero.com)
Subject: FW: 17814
Importance: High

This is the mat'l for the cable cutters. All 7075 this big is cut from plate. So where do we go from here?

LL

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: September-11-12 12:19 PM
To: 'Chantal Lavoie'
Cc: 'Lacelle, Linda'
Subject: RE: 17814

Chantal,

The mechanical properties of a 1.250" thick plate under AMS-QQ-A-250/11 are below the mechanical properties of a 1.250" thick bar under AMS-QQ-A-225/9 and AMS-QQ-A-200/11 so we can't accept to substitute as proposed below.

From: Chantal Lavoie [<mailto:clavoie@dartaero.com>]
Sent: Monday, September 10, 2012 12:31 PM
To: Ivers, Stan
Subject: RE: 17814

Sorry Stan,
I add send you this order last week please order.
Thanks
Chantal

From: Ivers, Stan [<mailto:Stan.Ivers@thyssenkrupp.com>]
Sent: September 10, 2012 8:07 AM
To: 'Chantal Lavoie'
Subject: 17814

Good morning Chantal

Please advise status on this p.o as nothing is on order and will miss delivery dates

Thanks

Regards

Stan Ivers
Inside Sales Rep
ThyssenKrupp material NA
905-532-1350
30shi@tkmna.com



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913396

Date: 16-Jun-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.3814 Wiper Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21185	Rev: N/C	DAS 38 9-88 SP17-6-15
2 ea	Part: 647.7810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21189	Rev: A	
2 ea	Part: 647.7811 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21190	Rev: A	
6 ea	Part: 647.7815 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21191	Rev: A	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: _____ Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913396

Date: 16-Jun-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

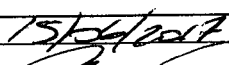
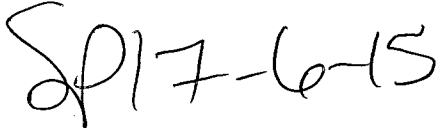
Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Certified Signature: 	
	Receiver Signature: 	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
		
	Made in Canada.	